

Work Order ID 52278

Tuesday, September 22, 2009 1:26:26 PM



Page 1

Item ID: D3943-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Stud

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

PS

Date:

09-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Hardinge

Memo

0.00

FOLIO REV: _____

DWG REV: _____

2-DEBURR AS REQUIRED

*****TAP DRILL FOR 1/4"-28 IN CENTER OF PART*****

DJP 09/09/25

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

DJP 09/09/25

6

Quality Control

Work Order ID 52278

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Page 2

Item ID: D3943-7

Accept

Revision ID: A

Item Name: Stud

Start Date: 9/23/2009 Start Qty: 6.00

Required Date: 10/2/2009 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

SL 09/09/25

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 135

0.00

Packaging

Memo

0.00

Packaging

09/09/28 (6)

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/09/28

u 31-09-28

Picklist Print

Page 1

Tuesday, September 22, 2009 1:26:25 PM

Work Order ID: 52278



Parent Item: D3943-7RevA



Parent Item Name: Stud

Start Date: 9/23/2009

Required Date: 10/2/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010R0.375		Purchased	No			100	f	0.0000	0.1200			
ROUND BAR .375												

Batch# 110860 X 0.12 f 511 09/09/20

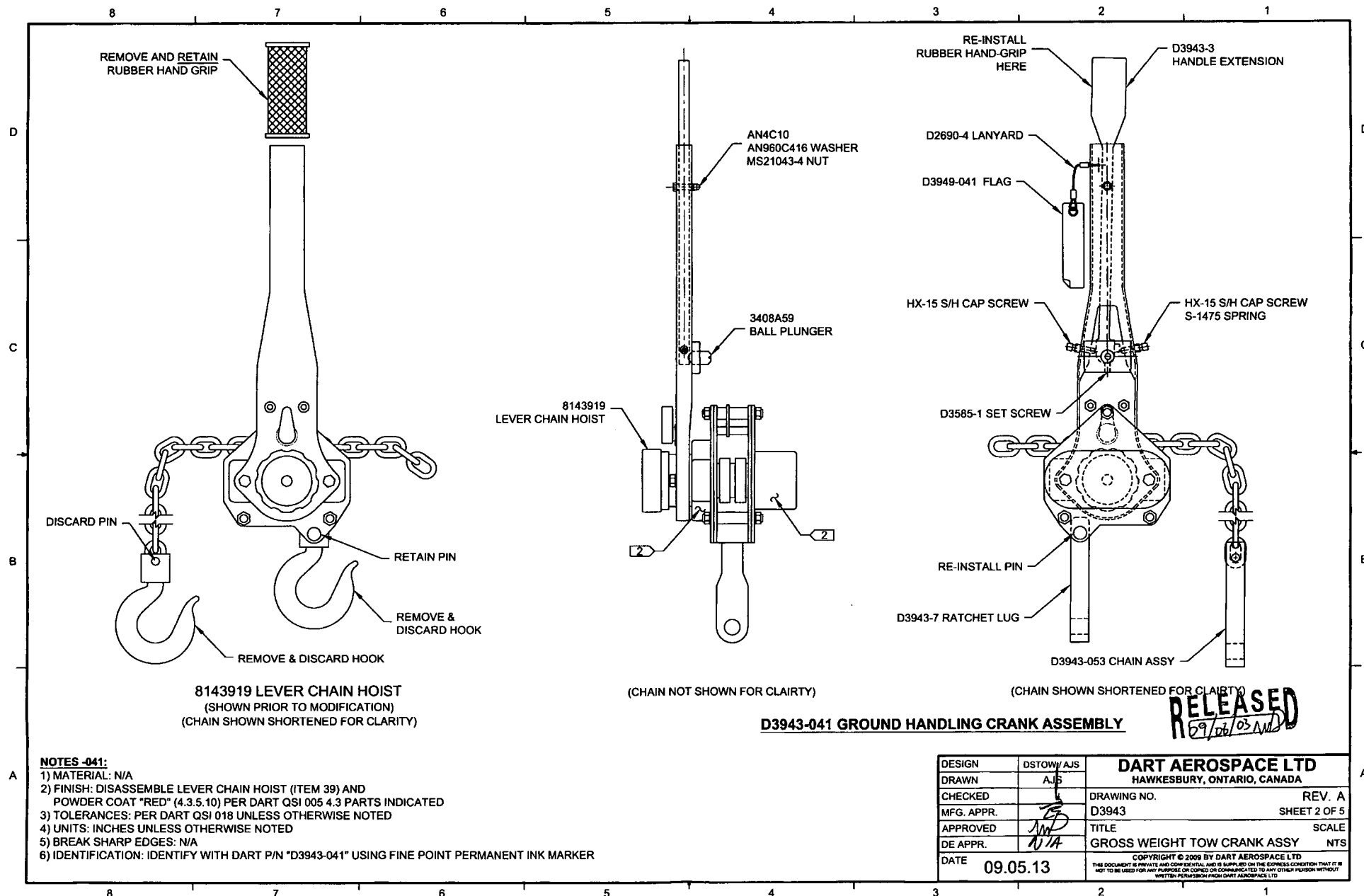
ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN4-10A	BOLT	
32	1			AN960-416	WASHER	
33	1			MS21042-4	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
41	1			S-1475	SPRING	REID SUPPLY
42	1			3408A59	BALL PLUNGER	McMASTER CARR
43	3			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 0.75 LG	HASKINS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52278

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09/05/13

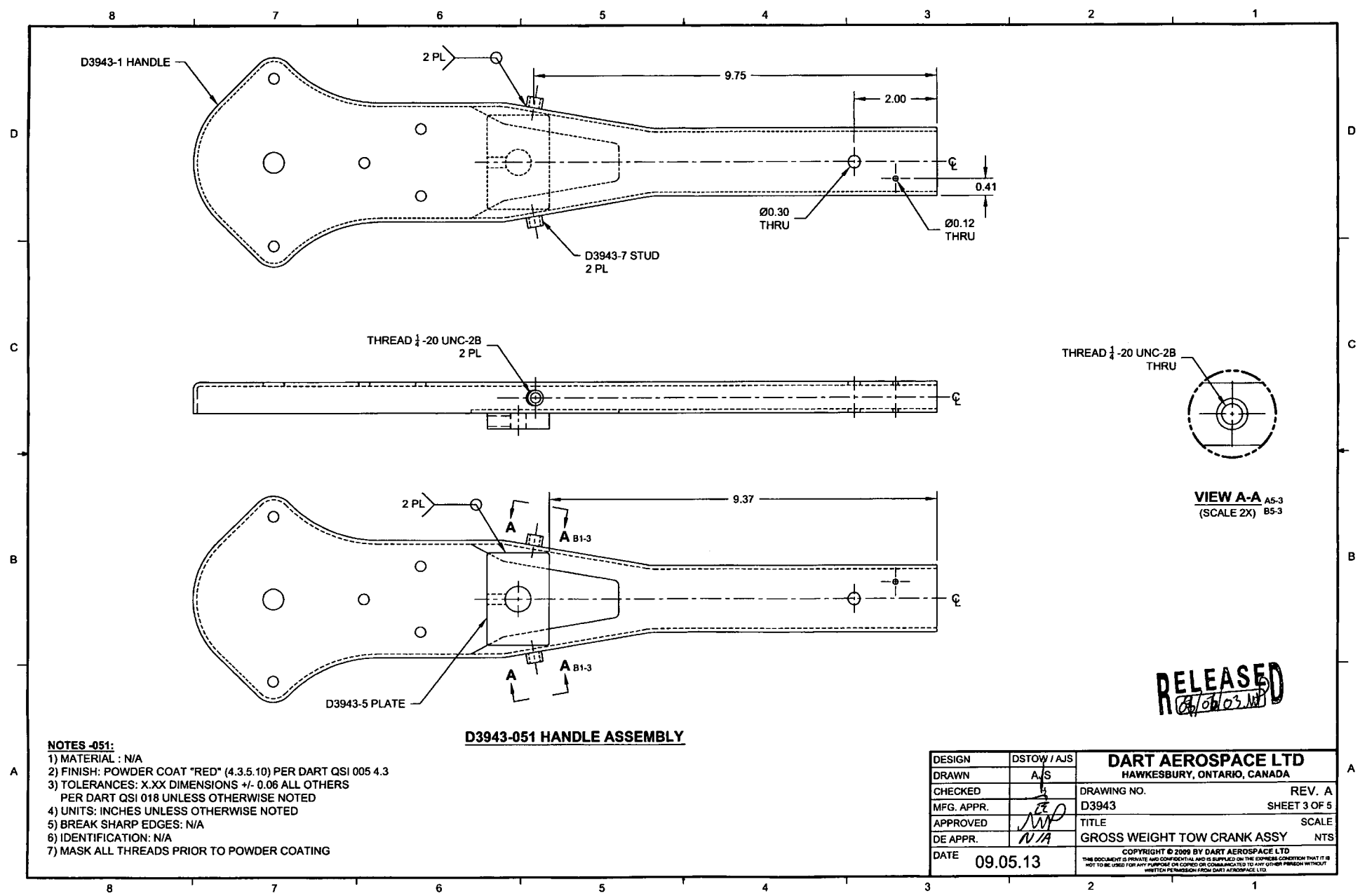
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3943	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	09.05.13	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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09/05/13

52278



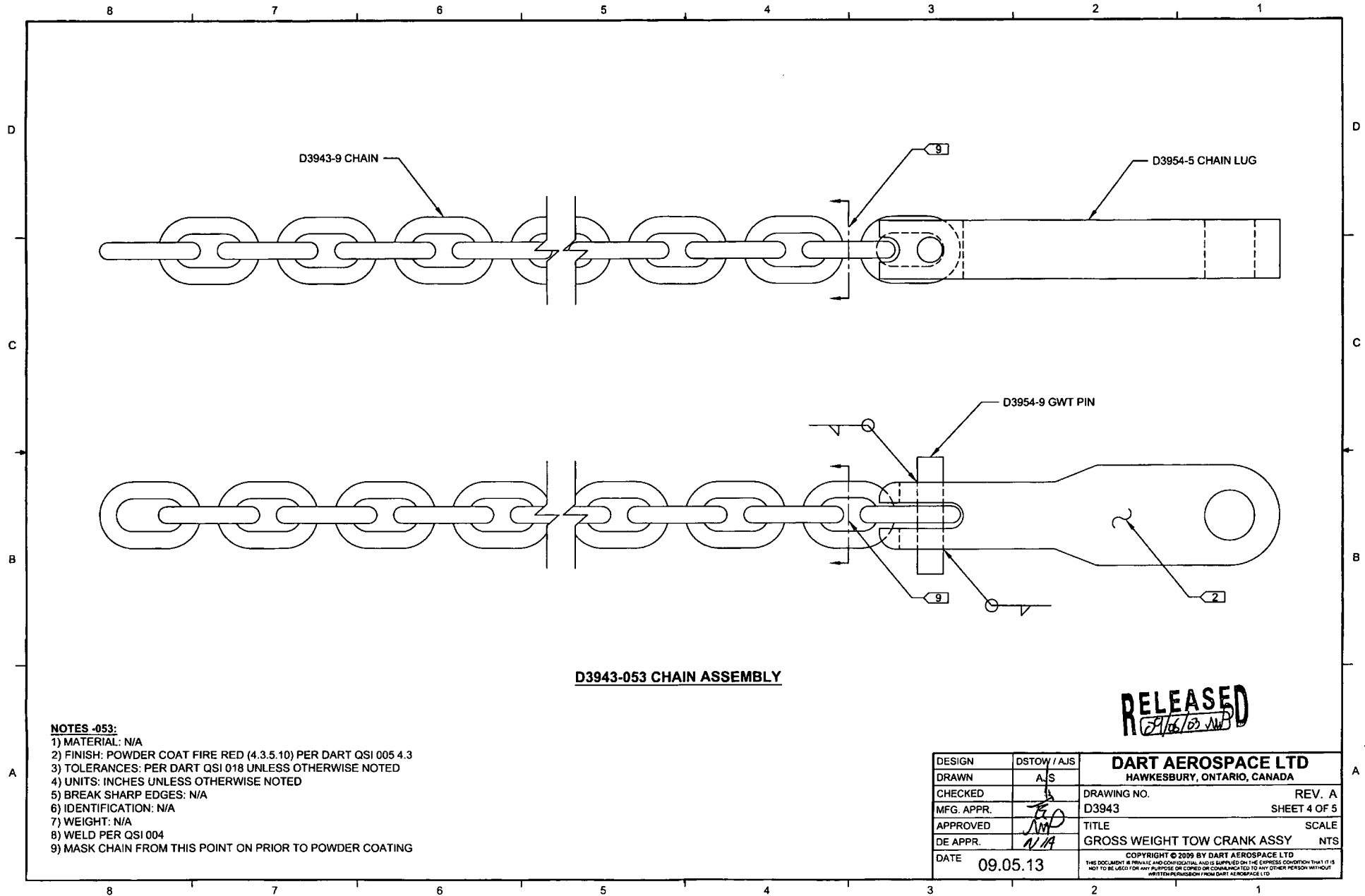
NOTES -051:

- 1) MATERIAL : N/A
- 2) FINISH: POWDER COAT "RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO POWDER COATING

D3943-051 HANDLE ASSEMBLY

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
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MFG. APPR.		D3943	SHEET 3 OF 5
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DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
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32278



D3943-053 CHAIN ASSEMBLY

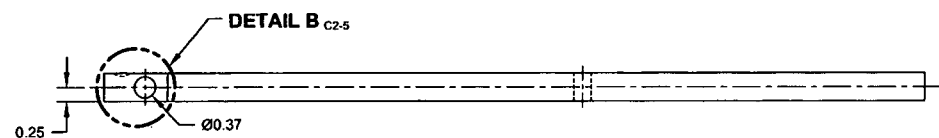
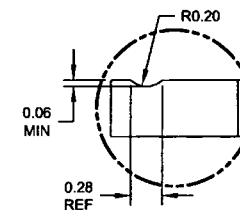
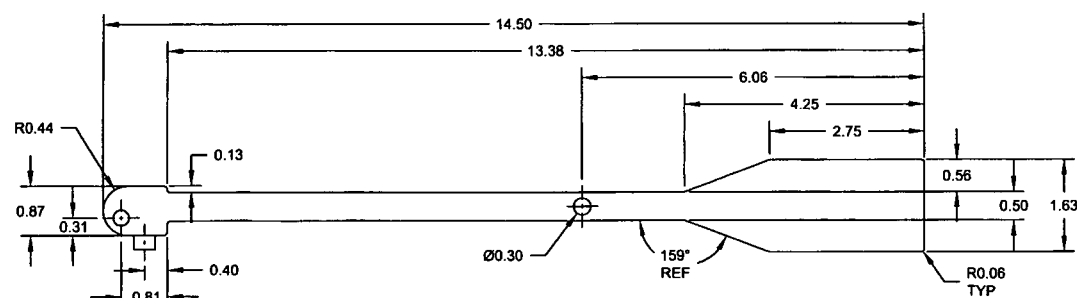
- NOTES -053:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELD PER QSI 004
 - 9) MASK CHAIN FROM THIS POINT ON PRIOR TO POWDER COATING

RELEASED
29/6/09

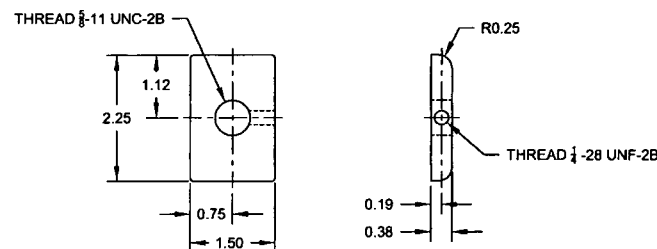
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DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
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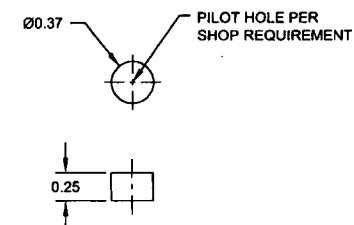
8 7 6 5 4 3 2 1



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

NOTES -11/-13:
1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A368/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR: MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A368/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH -3: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 PARTS INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

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8 7 6 5 4 3 2 1